Date:

Tuesday, 8/1/2006 11:29:35 AM

User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number : 28062B

Estimate Number : 10729

P.O. Number This Issue

:NIA

: 8/1/2006 : NC : NIA

: 27050B

S.O. No. : NIA

: SMALL /MED FAB

Part Number **Drawing Number**

Drawing Name

: D23245

: STRAP

Project Number

: D2324 REV C : N/A

Drawing Revision

: C

Material **Due Date** AI4:

: 8/18/2006

Qty:

40 Um: Each

Previous Run Written By

Prsht Rev.

First Issue

Checked & Approved By Comment

: Est. E 03.02(28)

Type

Reformat; Incorporated D2324-3 & D2324-5

J/RF

Additional Product

Job Number:



Seq. #:

1.0

Machine Or Operation:

Description:

WATER JET



FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2324

Dwg Rev: Prog Rev:_

2-Deburr if necessary

06:08:09 SAD

2.0

M304S16GA

304/316 .063 Sheet



Comment: Qty.:

0.0184 sf(s)/Unit

304/316 .063 Sheet

Total: 0.7360 sf(s)

Batch# M19059

40

3.0

QC2



Comment: DIMENSIONAL CHECK

Inspect dimensions per template D2324-5T1

540

70)

4.0

QC8

SECOND CHECK

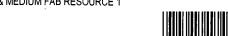
Comment: SECOND CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1





Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

Page 1

Dart Aerospace Ltd

	WORK ORDER CHANGES							
STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
		100						
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC	Corrective Action Section B		Verification		A		
DATE	STEP	Section A	Initial Design Mgr	Action Description Design Mgr	Sign & Date	Section C	Approval Design Mgr	Approval QC Inspector	
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Part No:	PAR #:	Fault Category:	NCR:	Yes No DQA:	Date: <u>06/89)</u>
NOTE: Date & initial all entries				QA: N/C Closed:	Date:

Tuesday, 8/1/2006 11:29:35 AM Date: ⊌ser: Kim Johnston **Process Sheet** Drawing Name: STRAP Customer: CU-DAR001 Dart Helicopters Services Job Number: 28062B Part Number: D23245 Job Number: Seq. #: **Machine Or Operation:** Description: PACKAGING RESOURCE #1 6.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 7.0 DC 2 20108/15 U 20108/15 Comment: DOCUMENT CONTROL Inspection Level 21 Job Completion

Dart Aerospace Ltd

W/O:			WO	RK ORDER CHANGES					
DATE STEP		PROCEDURE CHANGE		Ву	Date	Qty	Approval Mfg / Design Mgr	Approva QC Inspector	
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Part No):	PAR #:	Fault Category	y: NCR: `	res No	DQA:		Date:	
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H:\forms\Quality Assurance\approved forms\NCRWO revC

DART AEROSPACE LTD	Work Order:	28062B
Description: Strut	Part Number:	D2324-5
Inspection Dwg: D2324 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.38	+/-0.030	20.38	V		R-6	
Ø0.257	+0.006/-0.001	Ø0.259			Vern	
Ø0.191	+0.005/-0.001	\$ 0.192	V		Vern	
0.750	+/-0.010	0.756	V		Vern	
0.375	+/-0.010	0.379	1		Vern	
1.875	+/-0.010	1.878	/		Ver~	
3.000	+/-0.010	3.004	/		Vern	
3.375	+/-0.010	3.380	~		Vern Vern	
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Measured by:	SAD	Audited by:	36	Prototype Approval:	N/A	
Date:	06:08:09	Date:	06.08.09	Date:	N/A	7

Rev	Date	Change	Revised þչ	Approxed
Α	06.06.05	New Issue	KJ/JLM	
			771	

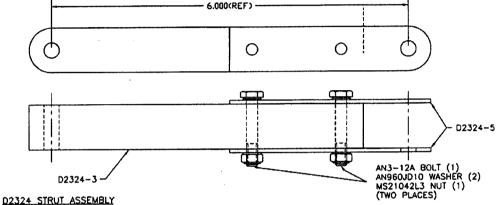
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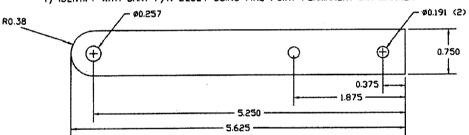
DRAWN BY DESIGN DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA B WILLIAMS PH REV. C CHECKED APPROVED DRAWING NO. D2324 SHEET 1 OF 1 SCALE DATE TITLE STRUT 04.12.14 **NEW ISSUE** 94.11.08 Α 96.05.07 UPDATE MATERIALS В

RELEASEL 04.12.16

UPDATE NOTES C 04.12.14



1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



D2324-3

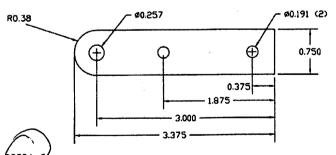
6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75 1) MATERIAL: (REF DART SPEC. M6061T6B0.750X00.750)

ACID ETCH AND ALODINE PER DART QSI 005 4.1 2). FINISH:

POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3 3) BREAK ALL SHARP EDGES 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED



AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK) (REF DART SPEC. M304S16GA)

POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3 2) FINISH: 3) BREAK ALL SHARP EDGES 0.005 TO 0.015

ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE